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HAWKESBURY, ONTARIO, CANADA

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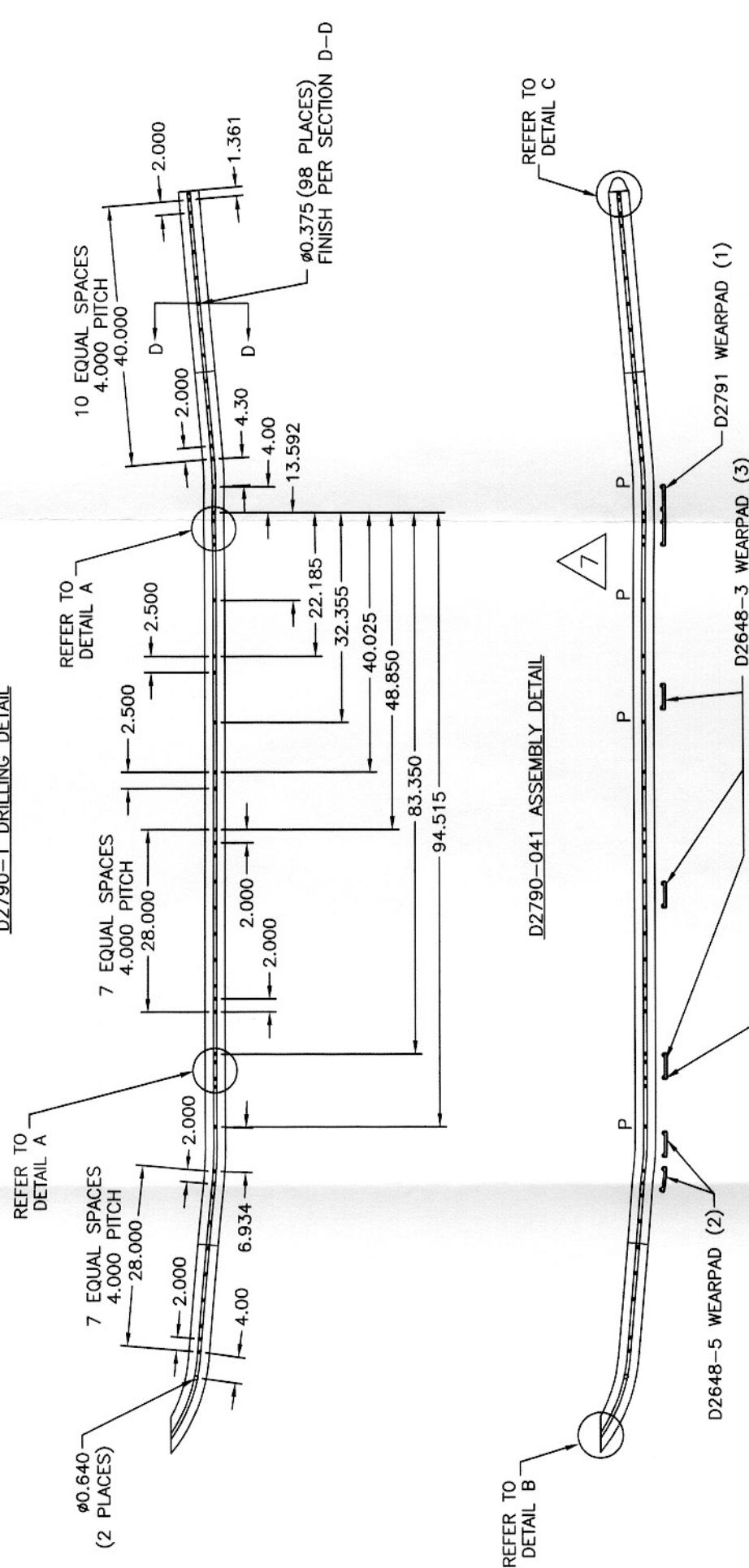
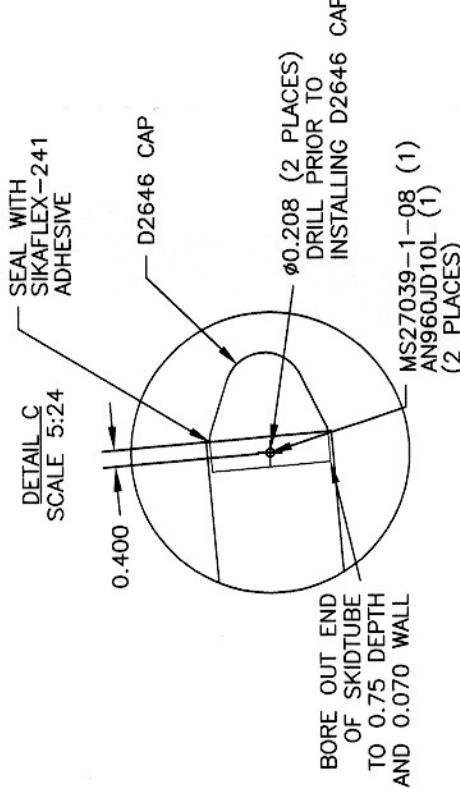
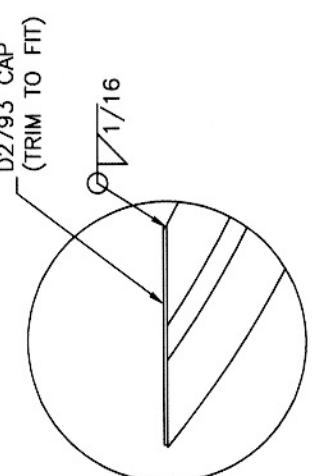
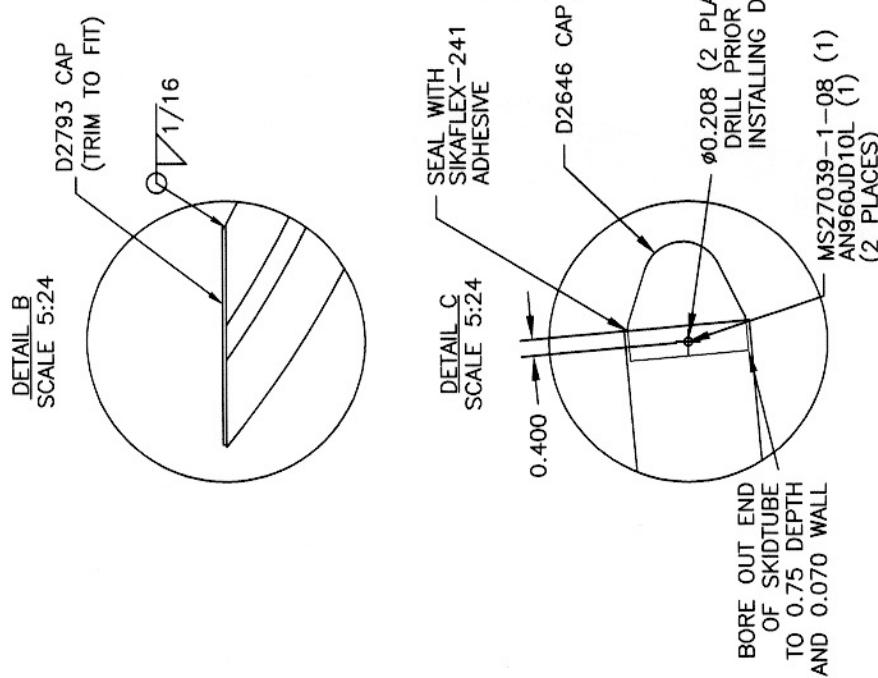
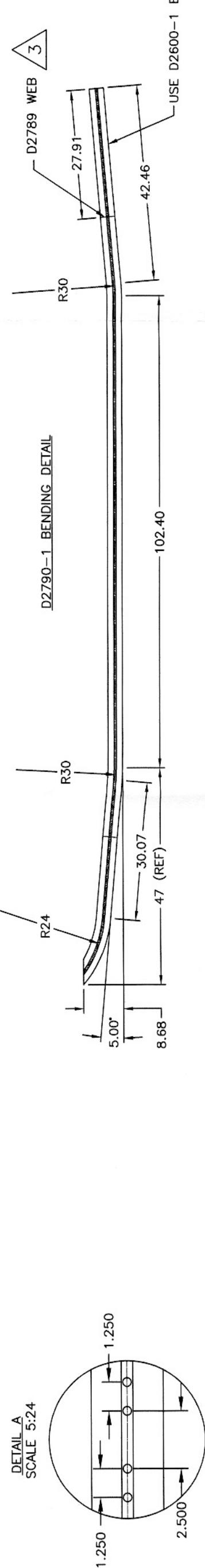
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		TITLE	SCALE
98.11.26		427 FLOAT SKIDTUBE ASSEMBLY	NTS
A	98.08.13	NEW ISSUE	
B	98.11.26	R30.0 WAS R18.5	

RELEASED
99.03.01 DS

Qty	Part Number	Description
X	D2790-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
3	D2648-3	WEARPAD
2	D2648-5	WEARPAD
49	D2649	CROSS BOLT SPACER
8	D2651-1	PLUG
8	D2651-3	O-RING
1	D2789	WEB
1	D2791	WEARPAD
1	D2793	CAP
54	ALS4-1032-130 or AKS7-1032-130	INSERT
56	AN960JD10L	WASHER
56	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 200 INCHES.*
- 3) INSERT D2789 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING.
- 4) USE DART DRILL TEMPLATE DT8161 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS4-1032-130 PER SECTION D-D (54 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2789 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (8 PLACES).



MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(54 PLACES)

INSTALL AFTER POWDER COAT

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19.03.01

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SET 2 OF 2